

Date: Friday, 14/11/2008 9:15:13 AM  
 User: Linda Lacelle

*slip 18/11*

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SLIDING DOOR BRACKET  
 Job Number : 43440  
 Estimate Number : 13643  
 P.O. Number :  
 This Issue : 14/11/2008 S.O. No. :  
 Prsht Rev. : NC  
 First Issue : / / Type : SMALL / MED FAB  
 Previous Run :  
 Written By : *[Signature]*  
 Checked & Approved By : *[Signature]*  
 Comment : Est Rev:A new issue 08-11.06 EC verified by:DD

Part Number : D36753  
 Drawing Number : D3675 REV PRELIM *BAD*  
 Project Number : N/A  
 Drawing Revision : PRELIM *B*  
 Material :  
 Due Date : 17/11/2008 Qty: 2 Um: Each

## Additional Product

**PRELIMINARY ISSUE**  
*RELEASED 01.11.05*

POSITIVE  
RECALL

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 M304S20GA 304/316 .040 Sheet



*MAT NOT PULLED*



Comment: Qty.: 0.1271 sf(s)/Unit Total: 0.2541 sf(s)  
 304 stainless steel 0.032" Sheet  
 Batch: *109057* *B 8-11-17*

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET  
 1-Cut as per Dwg D3675  
 Dwg Rev: *PRE* *B 8-11-17*  
 Prog Rev: *PRE*

*3*

2-Deburr if necessary *B 8-11-17*

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



*B 8-11-17*



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



*10611.18* *3*



Comment: SECOND CHECK

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE  
 Form as per Dwg D3675

*SB 08/11/19*

*3*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Friday, 14/11/2008 9:15:13 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SLIDING DOOR BRACKET

Job Number: 43440

Part Number: D36753

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



08-11-19 (3)



Comment: INSPECT WORK TO CURRENT STEP

7.0

POWDER COATING

POWDER COATING



M 106442



(3x)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

1:45  
320 °F  
2:15

M-L 08/11/19

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



PL



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-11-19

(3x)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



(3x)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

240

8/11/25

SP

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/25

M-L 08-11-25

Job Completion



POSITIVE RECALL

EFFECTIVE 08-11-14 AUTH L

RELEASED PL DATE 08-11-25



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

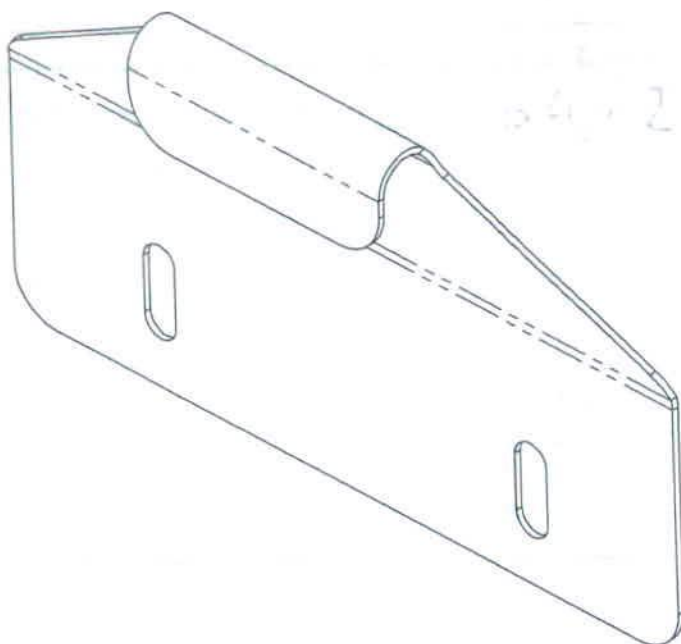
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**PRELIMINARY  
ISSUE**

*AJS 08.11.04*



**D3675-3 SLIDING DOOR BRACKET**  
(HINGE PANEL MOD)

*Wb 43440*

B	ADD -3 FOR HINGE PANEL MOD.	AJS	08.11.03
A	NEW ISSUE	AJS	08.03.27
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.		D3675	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SLIDING DOOR BRACKET SCALE
DE APPR.		(COMPOSITE DOOR)	NTS
DATE	08.11.03	COPYRIGHT © 2008 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

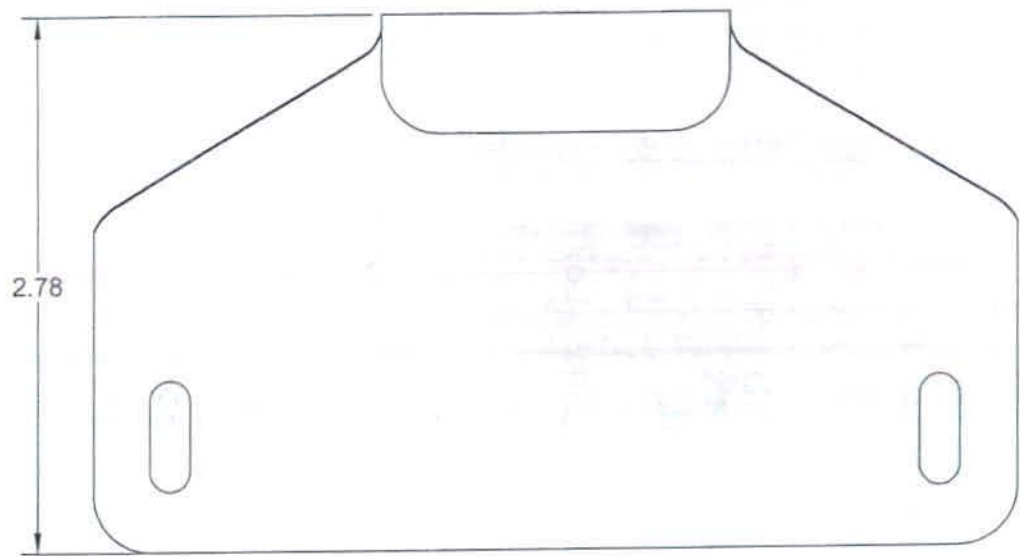
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

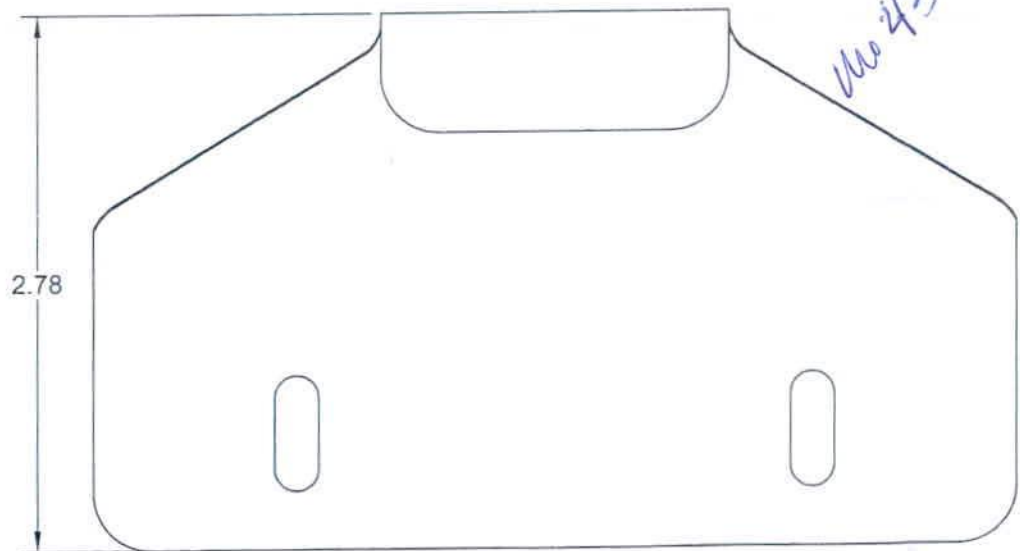
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D3675-1 SLIDING DOOR BRACKET**  
(MAKE FROM D3675-1F)



**D3675-3 SLIDING DOOR BRACKET**  
(MAKE FROM D3675-3F)  
(HINGE PANEL MOD)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

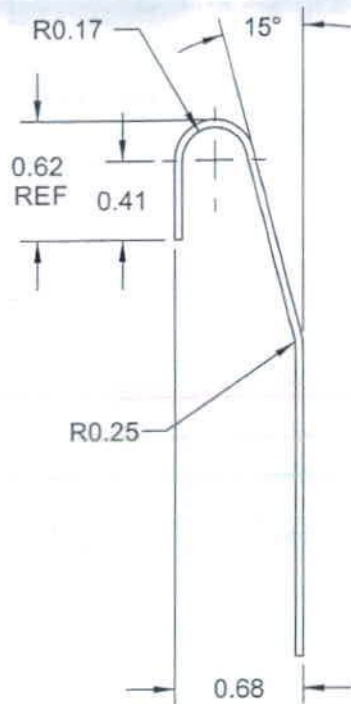
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

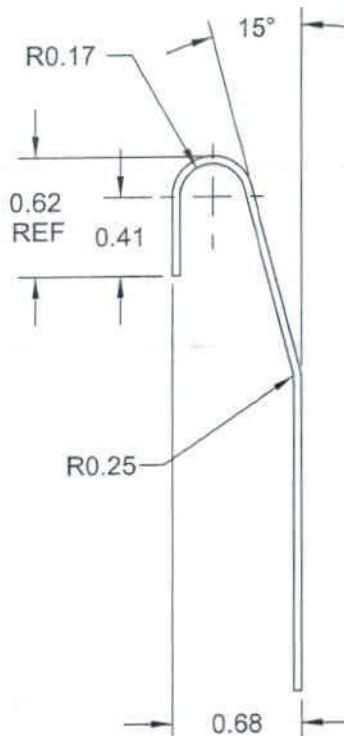
**NOTE:** Date & initial all entries





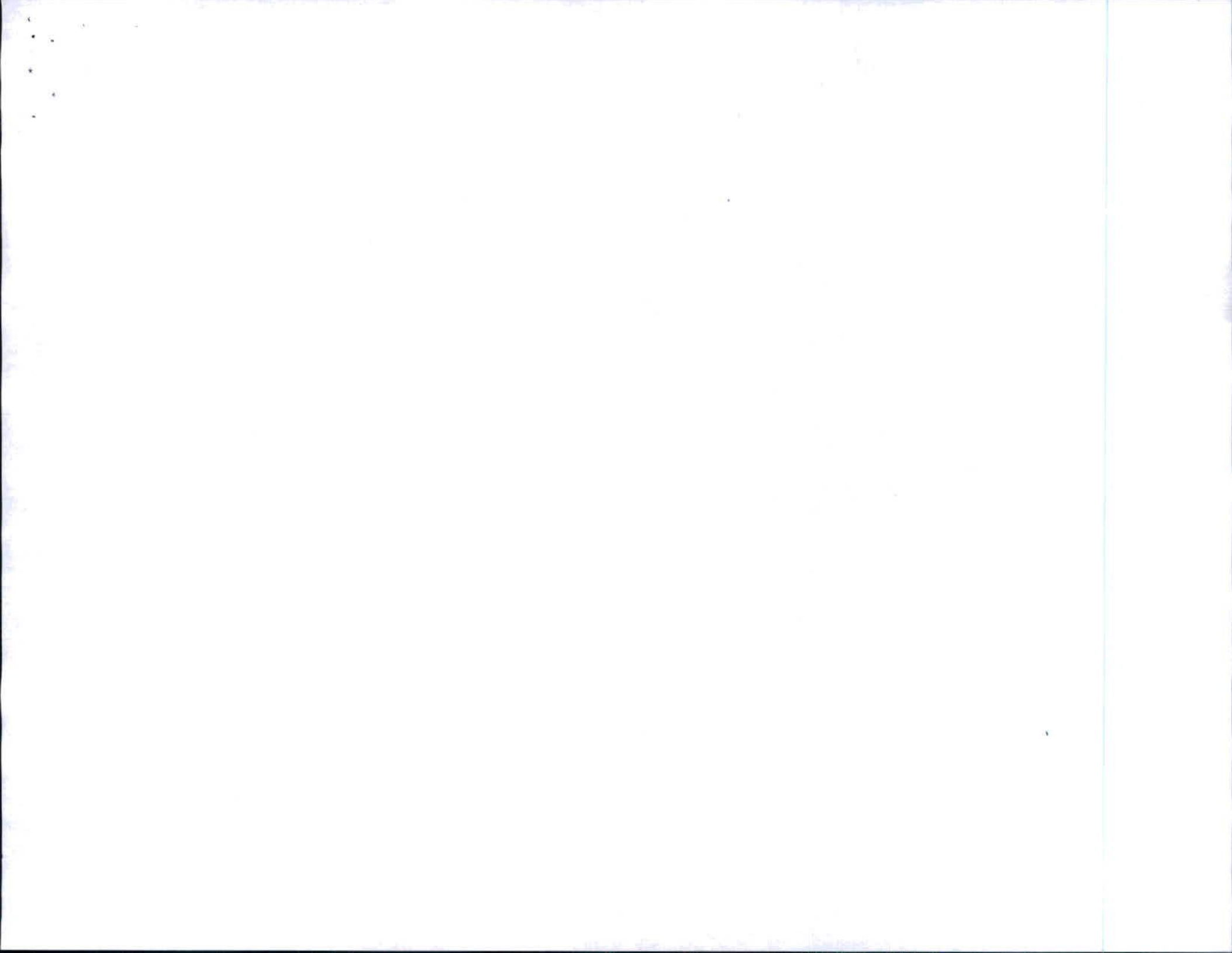
**PRELIMINARY  
ISSUE**

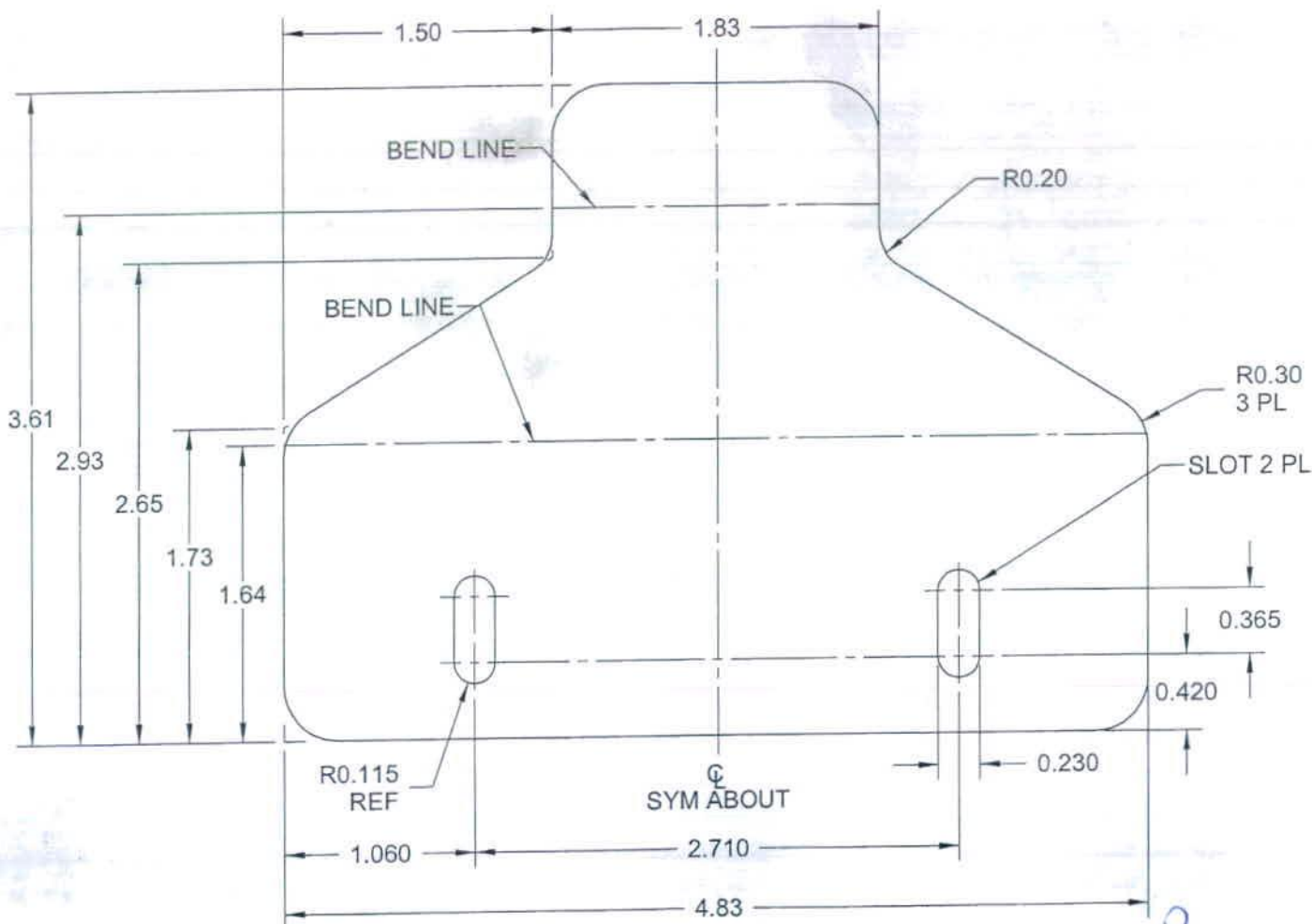
*13508.11.04*



*Wb 43440*

DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO. <b>D3675</b>	REV. B
MFG. APPR.	<i>[Signature]</i>	SHEET 2 OF 3	
APPROVED	<i>[Signature]</i>	TITLE <b>SLIDING DOOR BRACKET (COMPOSITE DOOR)</b>	SCALE NTS
DE APPR.		COPYRIGHT © 2008 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DATE	<b>08.11.03</b>		





**D3675-3F FLAT PATTERN**

**PRELIMINARY  
ISSUE**

08.11.03

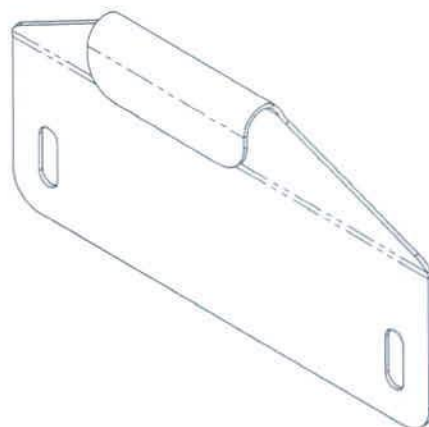
DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO. <b>D3675</b>	REV. B SHEET 3 OF 3
MFG. APPR.		TITLE <b>SLIDING DOOR BRACKET (COMPOSITE DOOR)</b>	
APPROVED	<i>[Signature]</i>		
DE APPR.		SCALE NTS	
DATE	<b>08.11.03</b>	COPYRIGHT © 2008 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



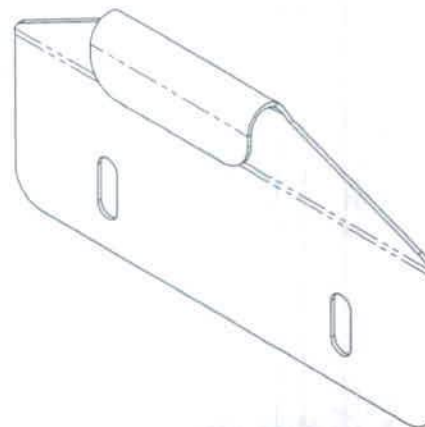








**D3675-1 SLIDING DOOR BRACKET**



**D3675-3 SLIDING DOOR BRACKET  
(HINGE PANEL MOD)**

*Mo 43440*

**RELEASED**  
*08.11.10*

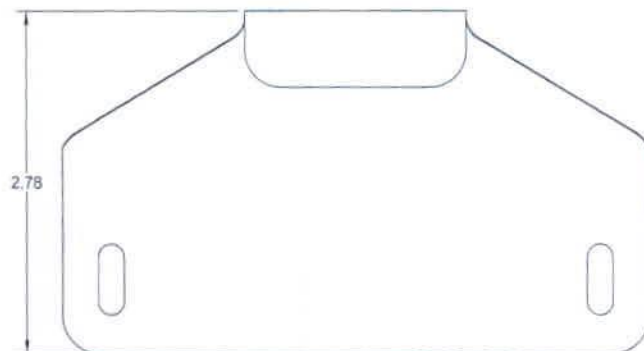
**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.040 THICK  
PER MIL-S-5059 (ANNEALED)  
REF. DART SPEC M304S
- 2) FINISH: POWDER COAT GREY SANDEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3675-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.15 lbs
- 8) THE D3675-1 SLIDING DOOR BRACKET IS A DERIVATIVE OF THE D3199-1 BRACKET.

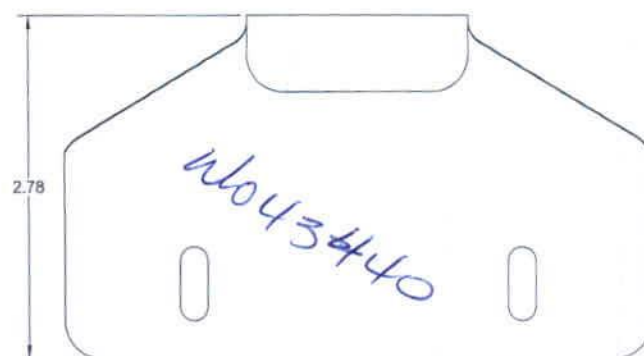
B	ADD -3 FOR HINGE PANEL MOD	AJS	08.11.03
A	NEW ISSUE	AJS	08.03.27
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3675	SHEET 1 OF 3
APPROVED		TITLE	SLIDING DOOR BRACKET SCALE
DE APPR.		(COMPOSITE DOOR)	NTS
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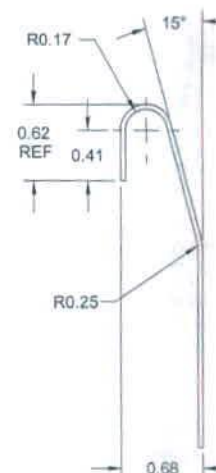
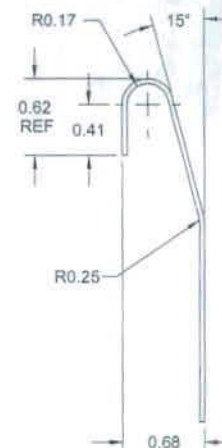




**D3675-1 SLIDING DOOR BRACKET**  
(MAKE FROM D3675-1F)



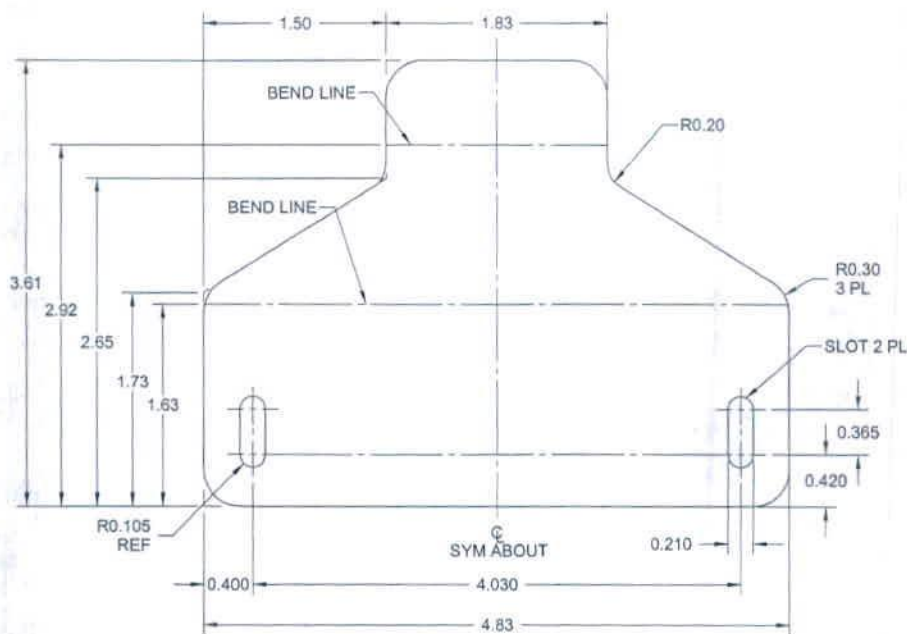
**D3675-3 SLIDING DOOR BRACKET**  
(MAKE FROM D3675-3F)  
(HINGE PANEL MOD)



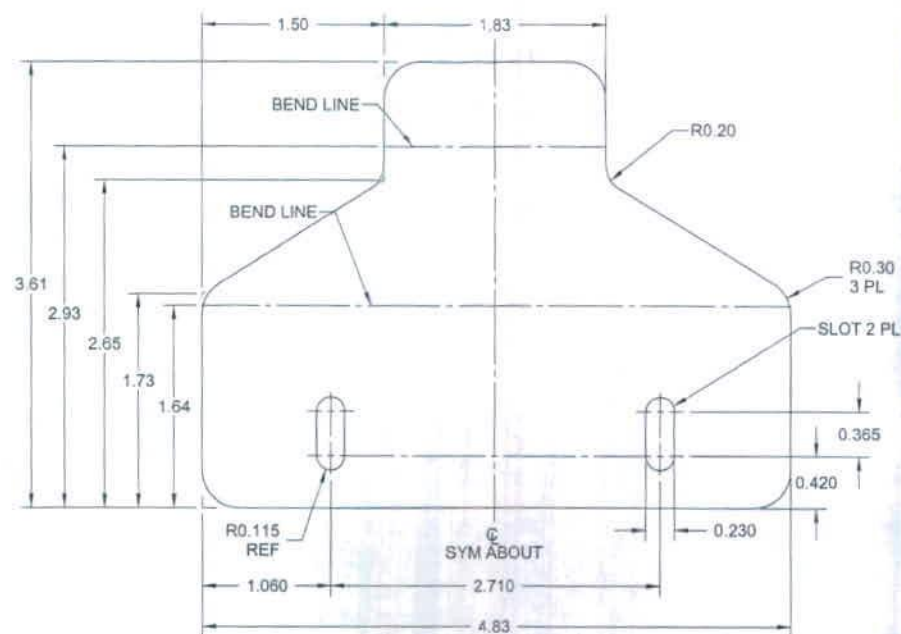
RELEASED  
03-11-10

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3675	SHEET 2 OF 3
APPROVED		TITLE	SLIDING DOOR BRACKET
DE APPR.		(COMPOSITE DOOR)	SCALE
DATE	08.11.03		NTS
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**D3675-1F FLAT PATTERN**



**D3675-3F FLAT PATTERN**

*66043440*

**RELEASED**  
08.11.03

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	<b>D3675</b>	SHEET 3 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>SLIDING DOOR BRACKET (COMPOSITE DOOR)</b>	NTS
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